

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001989**Date Inspected:** 25-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b> Yes No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b> Yes No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b> Yes No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b> Yes No N/A
				<b>Delayed / Cancelled:</b> Yes No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG side and end panels	

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for Magnetic particle Testing (MT) relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG bay 4

Due to ZPMC ferry cancellation QA arrival time was delayed until 1900 hrs. Upon arrival QA was instructed to perform 10% MT verification inspection of fillet welds joining bar and/or T stiffeners to the following side and end panels in OBG bay 4:

SP-091-001 welds 002 thru 029  
EP-011-001 welds 001 thru 004  
EP-006-001 welds 001 thru 004  
EP-007-001 welds 011 thru 014  
EP-019-001 welds 005 thru 008  
EP-018-001 welds 005 thru 008  
EP-020-001 welds 005 thru 008  
EP-008-001 welds 001 thru 004  
EP-012-001 welds 001 thru 004  
EP-009-001 welds 001 thru 004

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## WELDING INSPECTION REPORT

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The above list of panels was compiled by ZPMC Quality Control (QC) and submitted to Caltrans QA office in the form of a "notification of witness inspection" sheet at approximately 0800 hrs on this date. According to the above mentioned notification ZPMC QC would commence MT inspection of the above mentioned fillet welds at approximately 0830 hrs.

Caltrans QA inspector Steve Hall arrived in OBG bay 4 at approximately 2000 hrs to perform 10% MT verification inspection on the above mentioned panels. QA was unable to locate all but one of the panels (SP-091-001. QA performed the required 10% MT verification on this panel and all of the areas tested appeared to be compliant with the contract documents. Refer to QA MPT inspection report# MPT-shall-000001 dated 04/25/08 for side panel SP-091-001 for further details.

### Summary of Conversations:

No relevant conversations were held today concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer
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